

October 5, 2009 2:52:48 PM



Accept

**Setup Start**

Stop

**Cust Item ID:**

Start Date: 06/10/2009 **Start Qty:** 20.00



Customer:

Required Date: 13/10/2009 **Req'd Qty:** 20.00



Reference:

Run Start

**Approvals:**

Process Plan:

Date: 09-10-5

Tooling:

Date:

Stop






QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3414	Rev B								
100		0.00							
									
Bandsaw	Memo	0.00							
Jeaspa Bandsaw	Cut blanks: 2.50" x 0.500" x 2.250" long								
						20	0		
110		0.00							
									
HAAS I	Memo	0.00							
HAAS CNC vertical machine #1	Machine as per Folio FA569 and Dwg D3414 Identify as D3414-3 □ Dwg Rev <u>B</u> Folio Rev <u>AA</u>								
						20	0		
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
									
QC	Memo	0.00							
Quality Control									
						20	0		

Work Order ID 52652

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Page 2

Item ID: D3414-3

Accept



Setup Start



Revision ID: B

Stop



Item Name: Lug

Start Date: 06/10/2009 Start Qty: 20.00



Cust Item ID:

Required Date: 13/10/2009 Req'd Qty: 20.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

130 QC8- Inspect parts - second check 0.00



QC

Memo

0.00

Quality Control

mf 09/10/11

20 *0*

140 Identify as per dwg & Stock Location: *W/1011* 0.00



Packaging

Memo

0.00

Packaging

09/10/13 (20)

150 QC21- Final Inspection - Work Order Release 0.00



QC

Memo

0.00

Quality Control

09/10/13 *MF*

MF
09-10-13

Picklist Print

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Page 1

Work Order ID: 52652

Parent Item: D3414-3RevB

Parent Item Name: Lug

Comments:

Start Date: 05/10/2009

Required Date: 13/10/2009

Start Qty: 20.00

Required Qty: 20.00

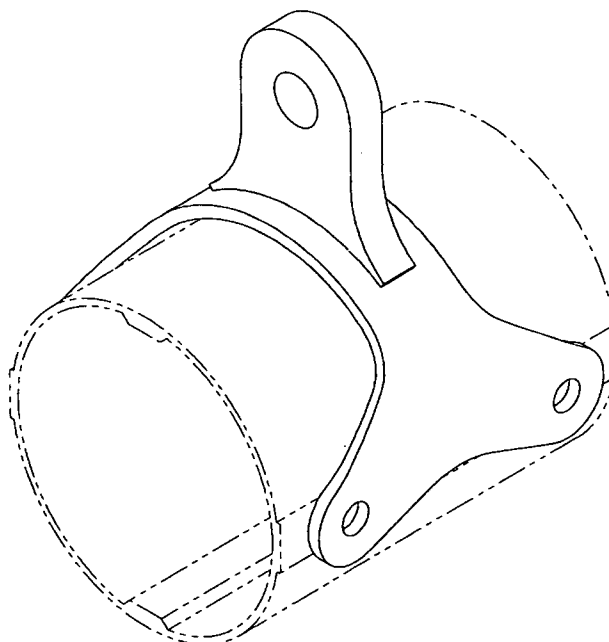
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304B0.500X2.500		Purchased	No				f	94.1165	118.0000			
304 BAR .500 x 2.50												

25 09/10/09

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	94.1165	
110966	2.9	
111330	3.16	
112320	12	
112347	9.6465	
112697	12.1	
112764	48.44	
18929	5.87	

3.75

ITEM No.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D3414-041	LUG ASSEMBLY
2	1	D3414-1	LUG BRACKET
3	1	D3414-3	LUG



D3414-041 LUG ASSEMBLY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 52652

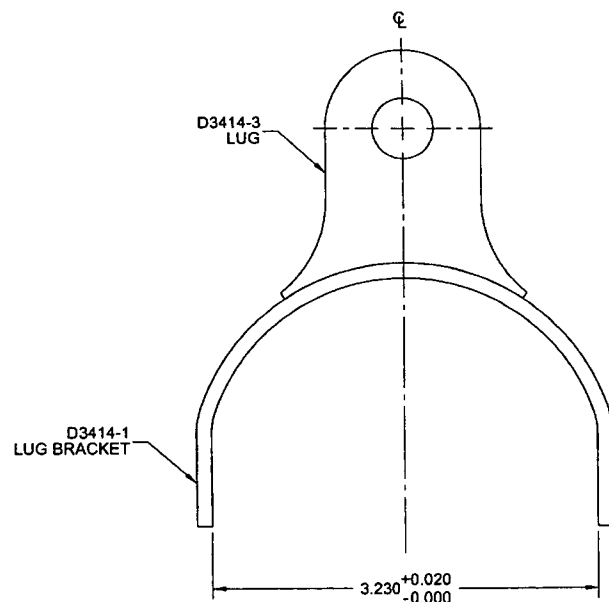
Pl 09-10-5

RELEASED
8/18/05

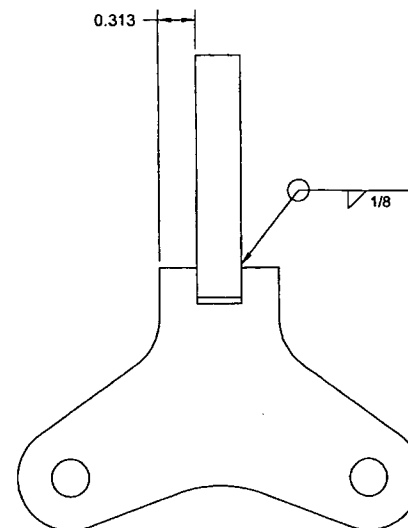
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3414-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.52 lbs

C	BREAK SHARP EDGES FOR -3 NOW 0.030-0.060 WAS 0.010-0.030 (ZN A7-3)	CP	09.06.17
B	DRAWING REDRAWN IN SOLIDWORKS WITH CURRENT STANDARDS AND TRANSFERRED TO "B" SIZE BORDER. FLAT PATTERN FOR -1 INCREASED IN LENGTH TO PREVENT FOULING AT INSTL (SEE PAR 188). FLAT SPOTS REMOVED FROM -1 (PART NOW "J" SHAPED) FOR EASE OF MANUFACTURE. B7-3 ADDED TOLERANCE TO 3.230 DIM. C2-3 1.12 DIM WAS 1.20.	AJS	08.09.23
A	NEW ISSUE	CP	05.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	CP		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D3414	SHEET 1 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	LUG ASSEMBLY	NTS
DATE	09.06.17	<small>COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



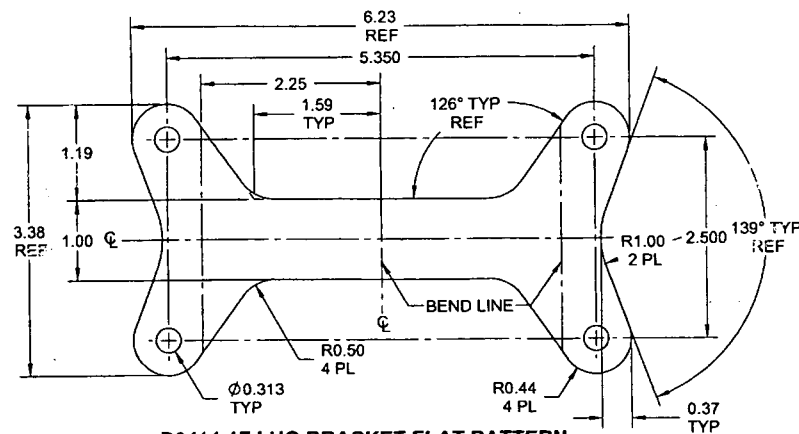
D3414-041 LUG ASSEMBLY



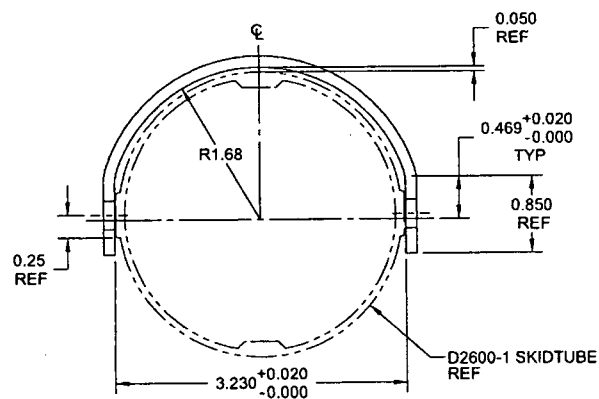
W/0
52652

RELEASED
04/18/17

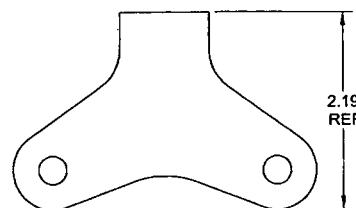
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	CP		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3414	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		LUG ASSEMBLY	NTS
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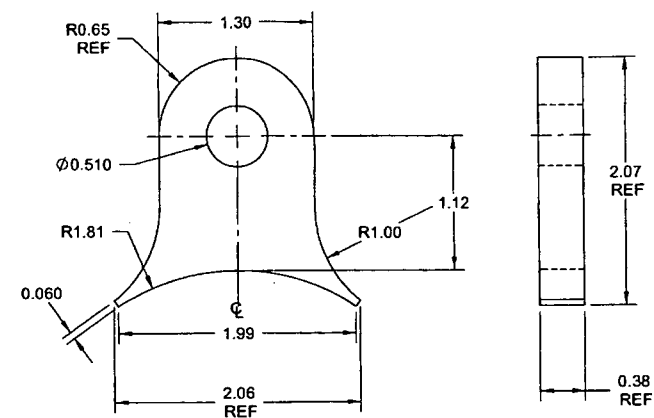
D3414-1F LUG BRACKET FLAT PATTERN



D3414-1 LUG BRACKET



SIDE VIEW FOR REF ONLY



D3414-3 LUG

u/o 52652

RELEASED

NOTES:

1) MATERIAL: -1: AISI 304/316 STAINLESS STEEL SHEET, 12 GAUGE (0.100 THICK)
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304S12GA

-3: AISI 304/316 STAINLESS STEEL PLATE
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304S

2) FINISH: N/A

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: -1: 0.010 TO 0.020 MAX
-3: 0.030 TO 0.060 MAX

6) IDENTIFICATION: N/A

7) WEIGHT: N/A



DESIGN	QP	DART AEROSPACE LTD	
DRAWN	QP	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3414	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		LUG ASSEMBLY	NTS
DATE	09.06.17	COPYRIGHT © 2005 BY DART AEROSPACE LTD	
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